

Work Order ID 64242

Page 1

Tuesday, November 30, 2010 1:42:01 PM

Item ID: D4271-013

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Aft Beam Assembly

Start Date: 11/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 12/1/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MFDate: 10-11-30 Tooling: _____ Date: _____

Run Start

QC: ✓

Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D4271	<u>PA2</u>
-------	------------

100		0.00	<i>EP, 0/12/01 ①</i>					
-----	--	------	----------------------	--	--	--	--	--



Small Fab	Memo	0.00	<i>on PA1 PA2 day</i>					
-----------	------	------	-----------------------	--	--	--	--	--

Small Fab	Memo	1- Pick and Assemble as per dwg	<i>10/12/01</i>					
-----------	------	---------------------------------	-----------------	--	--	--	--	--

110	QC5- Inspect part completeness to step on W/O	0.00 - <i>inspects to hand changes</i>	<i>on PA1 PA2 day</i>					
-----	---	--	-----------------------	--	--	--	--	--



QC	Memo	0.00	<i>10/12/01</i>					
----	------	------	-----------------	--	--	--	--	--

Quality Control	Memo	0.00	<i>①</i>					
-----------------	------	------	----------	--	--	--	--	--

- 013

120	Identify as per dwg & Stock Location: _____	0.00	<i>18/12/11 cf</i>					
-----	---	------	--------------------	--	--	--	--	--



Packaging	Memo	0.00	<i>cf</i>					
-----------	------	------	-----------	--	--	--	--	--

Packaging	Memo	0.00	<i>cf</i>					
-----------	------	------	-----------	--	--	--	--	--

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item Name: Aft Beam Assembly

Start Date: 11/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 12/1/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC21- Final Inspection - Work Order Release	0.00							

QC



Memos

0.00

Quality Control


 10-12-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Tuesday, November 30, 2010 1:42:00 PM

Work Order ID: 64242



Parent Item: D4271-013



Parent Item Name: Aft Beam Assembly

Start Date: 11/30/2010

Required Date: 12/1/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.11.18 new issue DD verf:EC

Component Item ID/ Item Name	Item ID	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D4148-3 			Manufactured	No			100	Each	7.0000	1	1		<i>E510/12/01</i>	
Stud Receiver, Lower														
					<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
					GA			1						
					63449			1						
					ST132			6						
					63722			6						
D4148-5 <i>PD</i> 			Manufactured	No			100	Each	4.0000	1	1		<i>E510/12/01</i>	
Eyebolt Stud														
					<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
					GA			4						
					61005			2						
					63450			2						
D4274-3 <i>PB</i> 			Manufactured	No			100	Each	2.0000	2	2		<i>E510/12/01</i>	
Plate, Aft Support														
					<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
					WA			2						
					63885			2						
✓ D4276-1 			Manufactured	No			100	Each	1.0000	1	1		<i>E510/12/01</i>	
Aft Beam														
					<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
					WA			1						
					63882			1						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

Page 2

Tuesday, November 30, 2010 1:42:00 PM

Work Order ID: 64242



Parent Item: D4271-013



Parent Item Name: Aft Beam Assembly

Start Date: 11/30/2010

Required Date: 12/1/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C12A



ANF ✓

Purchased

No

100

Each

21.0000

8

8

EBro/12/01 ⑥

PTD

Bolts

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST351	21	
112314	8	
114761	11	
116022	2	

MS20615-4M18



Purchased

No

100

Each

357.0000

8

8

EBro/12/01

Rivet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST323	357	
114808	152	
115037	205	

MS21043-3



Purchased

No

100

Each

1,896.000

8

8

EBro/12/01 ⑥

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	76	
103691	76	
ST301	1820	
112314	1820	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/12/01	100	AN4C13A m 4114615 x B.4 NAS1149C0432R 4114742 x B.8 m 521043-4 4116188 x B.4	EF	10/12/01	1	NP 10/12/01	S 10/12/01

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Tuesday, November 30, 2010 1:42:00 PM

Work Order ID: 64242



Parent Item: D4271-013



Parent Item Name: Aft Beam Assembly

Start Date: 11/30/2010

Required Date: 12/1/2010

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

100

Each

3,445.000

16



Washer

16
JBr/12/01

12

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST297	3445	
115000	125	
115698	35	
115832	1285	
116025	2000	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

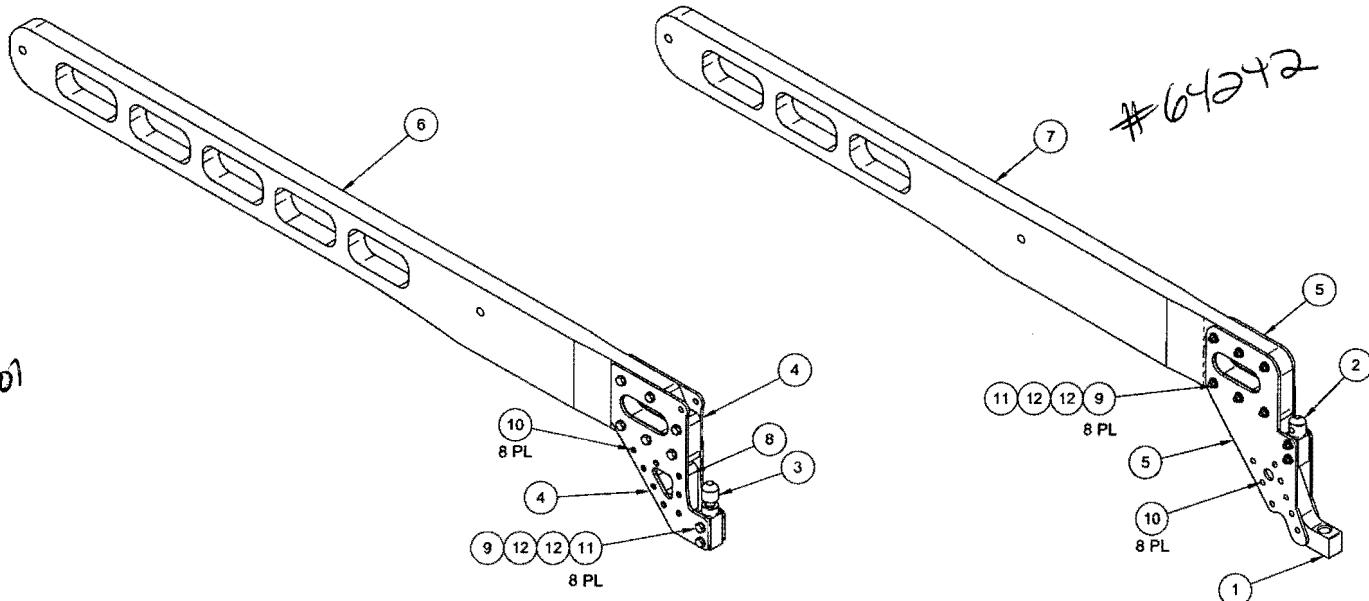
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -011	QTY -013	PART NUMBER	DESCRIPTION
			D4271-011	FWD BEAM ASSY
			D4271-013	AFT BEAM ASSY
1	1	1	D4148-3	STUD RECEIVER
2	1	1	D4148-5	EYEBOLT STUD
3	1	1	D4149-5	EYEBOLT STUD
4	2		D4274-1	PLATE, FWD SUPPORT
5	2		D4274-3	PLATE, AFT SUPPORT
6	1		D4275-1	FWD BEAM
7	1	1	D4276-1	AFT BEAM
8	1		D4281-1	SPACER
9	8	8	AN3C12A	BOLT
10	8	8	MS20615-4M18	RIVET
11	8	8	MS21043-3	NUT
12	16	16	NAS1149C0332R	WASHER

-2 72 AN4C13A Bolt
 +4 1/4 NAS1149C0432R washer
 -2 1/2 MS21043-4 nuts

MP 10/12/01



D4271-011 FWD BEAM ASSEMBLY

D4271-013 AFT BEAM ASSEMBLY

PRELIMINARY ISSUE
 Nov 17, 2010 JPH

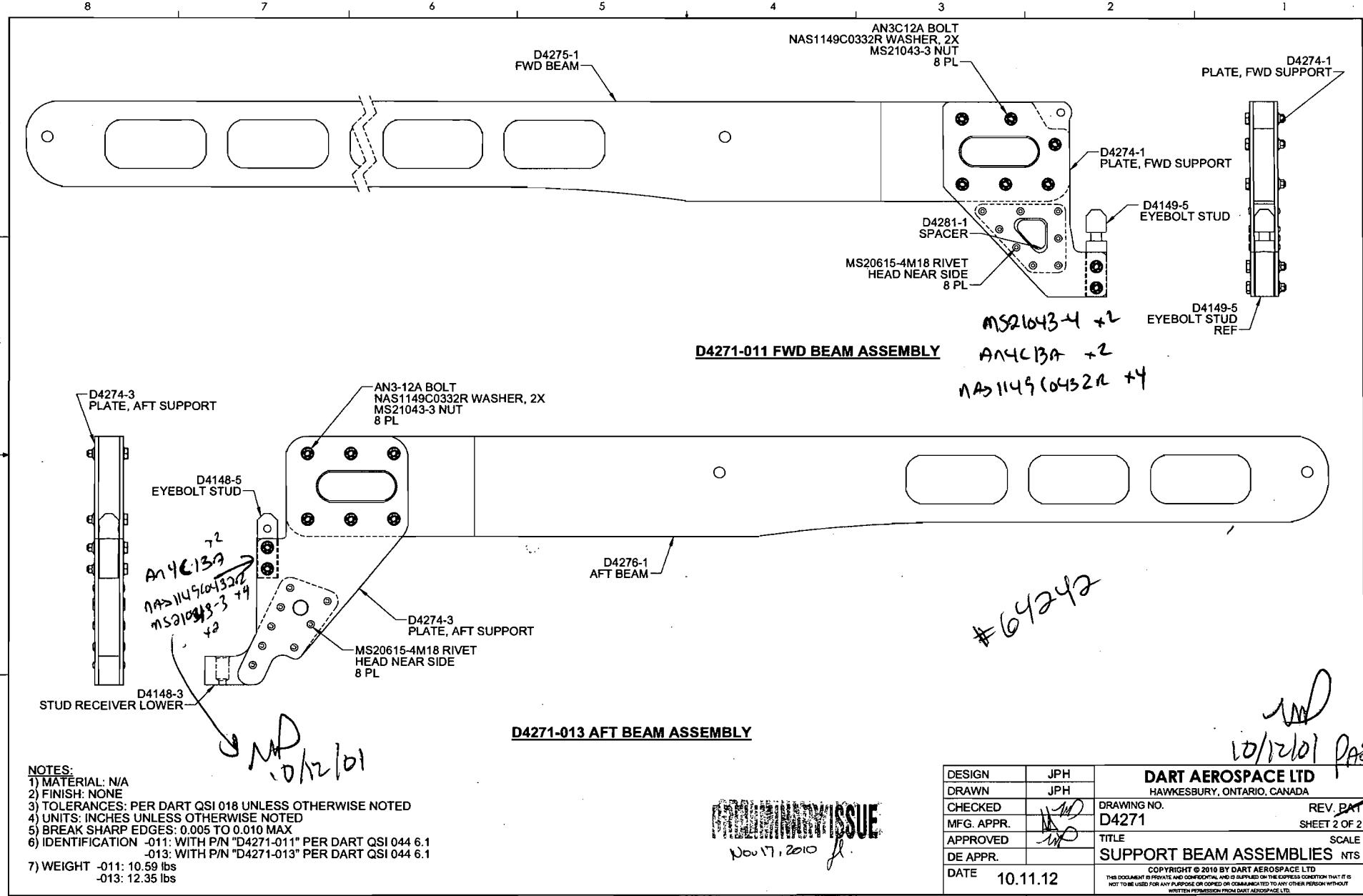
PA1	PRELIMINARY	JPH	10.11.12
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. PA
MFG. APPR.	JPH	D4271	SHEET 1 OF 2
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	SUPPORT BEAM ASSEMBLIES	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							WJS

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -011	QTY -013	PART NUMBER	DESCRIPTION	8	7	6	5	4	3	2	1
			D4271-011	FWD BEAM ASSY								
			D4271-013	AFT BEAM ASSY								
D	1	1	D4148-3	STUD RECEIVER								
	2	1	D4148-5	EYEBOLT STUD								
	3	1	D4149-5	EYEBOLT STUD								
	4	2	D4274-1	PLATE, FWD SUPPORT								
	5	2	D4274-3	PLATE, AFT SUPPORT								
	6	1	D4275-1	FWD BEAM								
	7	1	D4276-1	AFT BEAM								
C	8	1	D4281-1	SPACER								
	9	6	AN3C12A	BOLT								
	10	2	AN4C13A	BOLT								
	11	8	MS20615-4M18	RIVET								
	12	6	MS21043-3	NUT								
	13	2	MS21043-4	NUT								
	14	12	12	NAS1149C0332R	WASHER							
	15	4	4	NAS1149C0432R	WASHER							

D4271-011 FWD BEAM ASSEMBLY

D4271-013 AFT BEAM ASSEMBLY

B	ITEM 10 CHANGED FROM AN3C12A TO AN4C13A	SC	10.12.01
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION		
DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	12	D4271	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT BEAM ASSEMBLIES	NTS
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